

Work Order ID 59787

Friday, June 11, 2010 12:43:14 PM



Page 1

Item ID: D3874-2

Accept



Setup Start



Revision ID:

Item Name: Floor Protector

Stop



Start Date: 6/10/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 6/18/2010 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

Handwritten signature

Date:

10-6-11

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3874

A

100

0.00



Hand Thermo

Memo

0.00

Hand Finishing Thermoforming

1-Cut Sheet to required Blank size

Plt →

X4 BB 10/06/15

105

0.00



Hand Thermo

Dry Material

Memo

0.00

Hand Finishing Thermoforming

Dry Sheet as per QSI022 POLYCARBONATE


Temp: *240°F* *BB* *10/06/14*

Time IN: *4:30* *BB*

Time OUT: *7:00 AM* *WLC* *10/06/15*

W/O: 59787

WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
10/06/22	# 100	perm - change must ADD Qty # + Rev to header box.		10.06.23			S 10/06/22

Part No: D 3874-2 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 59787

Friday, June 11, 2010 12:43:14 PM



Page 4

Item ID: D3874-2

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Setup Start



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Item Name: Floor Protector

Start Date: 6/10/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 6/18/2010 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

170

Identify as per dwg & Stock Location

0.00



Packaging

Memo

0.00

Packaging

10-6-23 10 SF

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/06/23

10/06/23

Picklist Print

Friday, June 11, 2010 12:03:30 PM

Page 1

Work Order ID: 59787



Parent Item: D3874-2



Parent Item Name: Floor Protector

Start Date: 6/10/2010

Required Date: 6/18/2010

Comments: IPP Rev. A 09.02.06 New Issue DL
Add Step 105 Dry Material 10/04/21 DL

IPP Rev B

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MLEXS.118-90318-08		Purchased	No			100	sf	2,598.510	4.38	17.52			



Lexan Sheet

Location

Loc Qty

Loc Code

therm

113127

2598.51

2598.51

XY BB 10/06/14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	39787
Description: Floor Protector		Part Number:	D3874-2
Inspection Dwg: D3874 Rev: A		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than "	✓			
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

Measured by: B Date: 10/06/21

TRIMMING SECTION

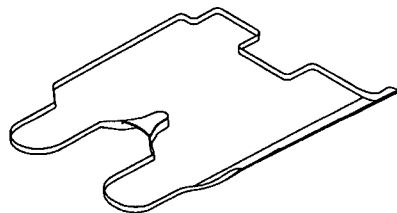
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.050	Min	0.050 0.070	✓			
0.065	Min	0.070	✓			
0.5	Min	0.544	✓			
21.9	REF	21.77				

Measured by: B Date: 10/06/21

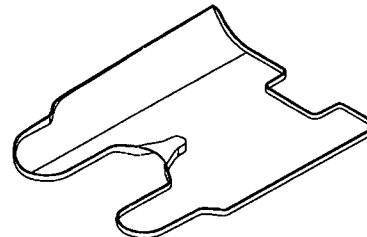
Audited by: Wh Date: 10/06/21

Prototype Approval: N/A Date: N/A

Rev	Date	Change	Revised by	Approved
A	09.09.15	New Issue	KJ	<u>[Signature]</u>



D3874-1 FLOOR PROTECTOR

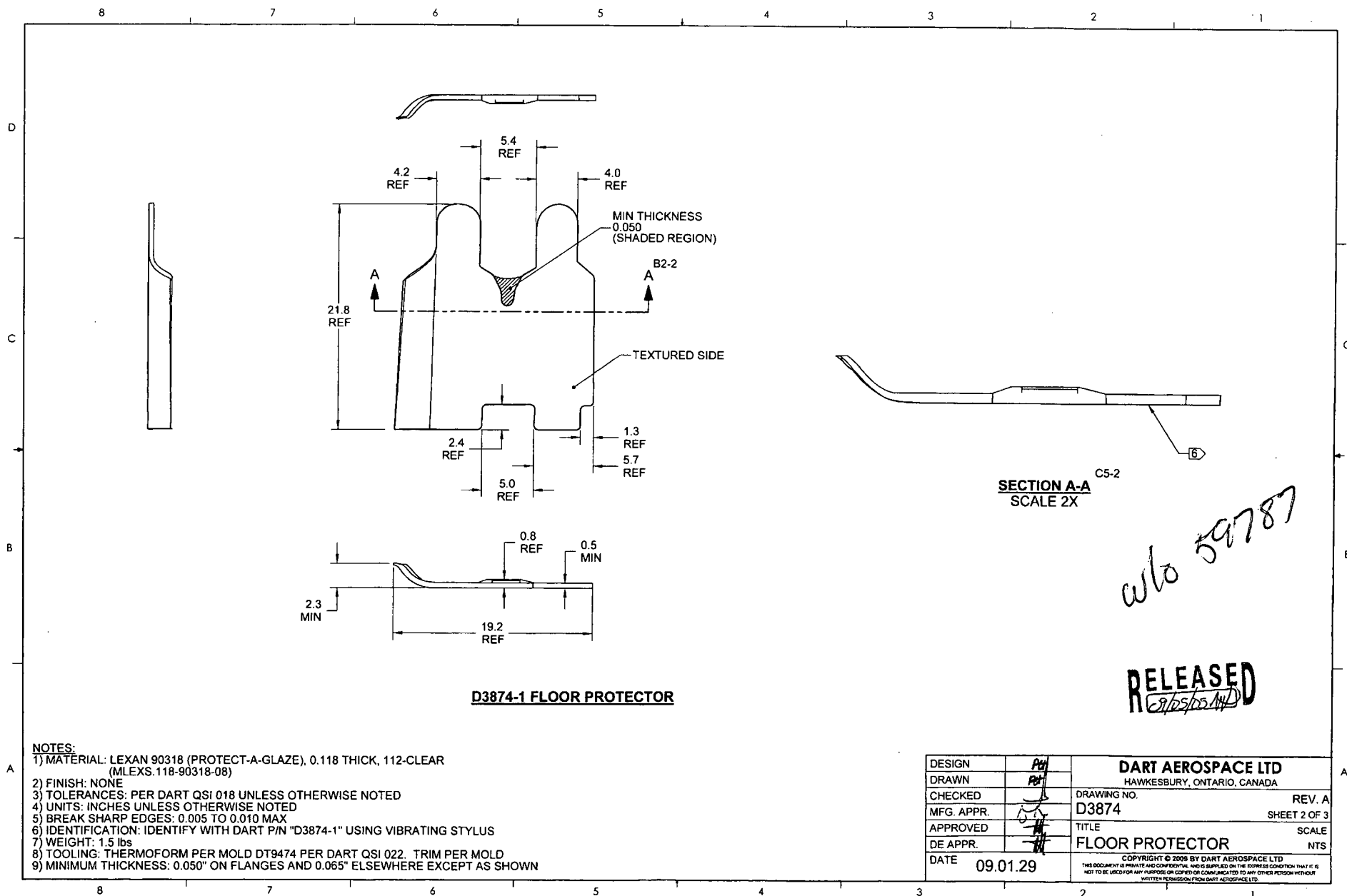


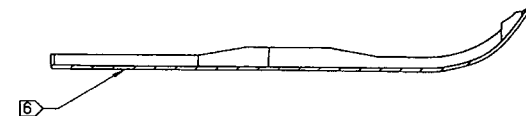
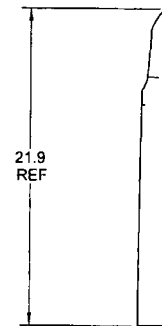
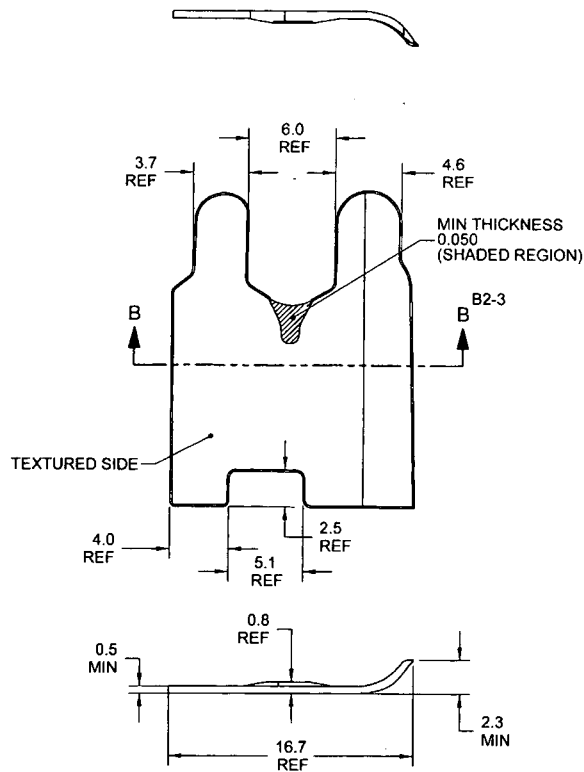
D3874-2 FLOOR PROTECTOR

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITH ORDER
WORK ORDER
NO. 59787
B810-6-11

RELEASED
29/05/09

A	NEW ISSUE	PH	09.01.29
REV.	DESCRIPTION	BY	DATE
DESIGN	<u>PH</u>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	<u>PH</u>		
CHECKED	<u>PH</u>	DRAWING NO.	REV. A
MFG. APPR.	<u>PH</u>	D3874	SHEET 1 OF 3
APPROVED	<u>PH</u>	TITLE	SCALE
DE APPR.	<u>PH</u>	FLOOR PROTECTOR	NTS
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SECTION B-B
SCALE 2X

D3874-2 FLOOR PROTECTOR

NOTES:

- 1) MATERIAL: LEXAN 90318 (PROTECT-A-GLAZE), 0.118 THICK, 112-CLEAR (MLEXS.118-90318-08)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3874-2" USING VIBRATING STYLUS
- 7) WEIGHT: 1.5 lbs
- 8) TOOLING: THERMOFORM PER MOLD DT9474 PER DART QSI 022. TRIM PER MOLD
- 9) MINIMUM THICKNESS: 0.050" ON FLANGES AND 0.055" ELSEWHERE EXCEPT AS SHOWN

DESIGN	Rev	DART AEROSPACE LTD	
DRAWN	Rev	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3874	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		FLOOR PROTECTOR	NTS
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RELEASED
29/05/09

w/o 59787